

Claims

1. Process for the manufacturing of frozen aerated products comprising;
 - 5 • providing two separate forming elements,
 - providing at least one open cavity on a surface of each forming element,
 - providing filling devices for filling said cavities with a frozen aerated material,
 - 10 • filling two cavities, one on each forming element, with a frozen aerated material,

wherein

- a. at least one of the cavities is filled with a frozen aerated product having an overrun of between 30% and 130%,
- 15 b. this product is then allowed to expand outside its cavity,
- c. the two cavities are then moved opposite one another and the frozen aerated product in each cavity is pressed against the frozen aerated product in the other cavity.

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2. Process according to claim 1 wherein the frozen aerated product is at a temperature of between -3°C and -20°C, preferably between -5°C and -15°C, even more preferably between -7 and -11°C, when filled unto the cavities.

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3. Process according to claim 2 wherein the two separate forming elements are a pair of parallel rollers wherein each roller has a multiplicity of open cavities on its surface, the rollers counter-rotating so that respective cavities in the two forming elements lie opposite one another and the frozen aerated product in a cavity of a first roller is pressed against the frozen aerated product in an opposite cavity of a second roller.

4. Process according to claim 3 wherein the rollers counter rotate at a variable rational speed.
5. Process according to claim 4 wherein the rotational speed of a roller is at its minimal value when a filling device is over a cavity of this roller and at a maximal value when a filling device is between two cavities.
6. Process according to claim 5 wherein a roller is brought to stop when a filling device is over a cavity.
7. Process according to claim 4 wherein the rotational speed of each roller is at its minimal value when a filled cavity of one roller faces a filled cavity of the other roller.
8. Process according to claim 7 wherein both rollers are brought to stop when a filled cavity of one roller faces a filled cavity of the other roller.
9. Process according to claims 5 and 7 wherein a minimal rotational speed of both rollers is reached when, at the same time, two filled cavities face each other and each filling device is over a cavity of each roller.
10. Process according to claims 6 and 8 wherein each roller is brought to a stop when, at the same time, two filled cavities face each other and each filling device is over a cavity of each roller.